

**Amendments To The Claims**

This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

1. (Currently Amended) A method for the manufacture of fluted rolls, in particular for corrugating machines, comprising the following steps:

- providing a fluted-roll blank (41) with a central longitudinal axis (44) and with a longitudinal direction (43) that is parallel thereto and with a surface (42);  
-- wherein the fluted-roll blank (41) has a swell;
- providing a grinding device (21) for grinding, on the surface (42), flutings (7, 8) that run in the longitudinal direction (43);  
  
-- the flutings (7, 8) comprising fluting heads (15) and roots (18) that are parallel to each other and are regularly and alternately distributed along the circumference of the surface (42); and
- grinding fluting heads (15) on the surface (42) by means of the grinding device (21),  
  
-- the fluting heads (15) having the same cross-sectional curvature in the longitudinal direction (43).

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2. (Original) A method according to claim 1, wherein the fluted-roll blank (41) has a diameter that varies in the longitudinal direction (43).

3. (Canceled)

4. (Original) A method according to claim 1, wherein a grinding wheel (27) that is displaceable in the longitudinal direction (43) is used in the grinding device (21).

5. (Original) A method according to claim 4, wherein a grinding wheel (27) is used, having two radially projecting annular beads (33, 34) and an annular recess (35) that is disposed there-between and stands back radially.

6. (Original) A method according to claim 5, wherein the annular recess (35) corresponds in cross-sectional shape to the curvature of the fluting heads (15).

7. (Original) A method according to claim 4, wherein the grinding wheel (27), upon grinding, is set to the surface (42) of the fluted-roll blank (41).

8. (Original) A method according to claim 1, wherein the grinding device (21), upon grinding of the fluting heads (15), grinds a part of the two roots (18) that adjoin the heads (15).

Claims 9-10. (Canceled)

11. (New) A method for the manufacture of fluted rolls, in particular for corrugating machines, comprising the following steps:

- providing a fluted-roll blank (41) with a central longitudinal axis (44) and with a longitudinal direction (43) that is parallel thereto and with a surface (42);

- wherein the fluted-roll blank (41) has a swell;

- providing a grinding device (21) for grinding, on the surface (42), flutings (7, 8) that run in the longitudinal direction (43);

- wherein a grinding wheel (27) that is displaceable in the longitudinal direction (43) is used in the grinding device (21); and

- the flutings (7, 8) comprising fluting heads (15) and roots (18) that are parallel to each other and are regularly and alternately distributed along the circumference of the surface (42); and

- grinding fluting heads (15) on the surface (42) by means of the grinding device (21),

-- wherein the rotating grinding wheel (27) is moved along the fluted-roll blank (41) and upwards on a guide (29) for height adjustment; and

-- the fluting heads (15) having the same cross-sectional curvature in the longitudinal direction (43).

12. (New) A method according to claim 11, wherein the fluted-roll blank (41) has a diameter that varies in the longitudinal direction (43).

13. (New) A method according to claim 11, wherein a grinding wheel (27) is used, having two radially projecting annular beads (33, 34) and an annular recess (35) that is disposed there-between and stands back radially.

14. (New) A method according to claim 13, wherein the annular recess (35) corresponds in cross-sectional shape to the curvature of the fluting heads (15).

15. (New) A method according to claim 11, wherein the grinding wheel (27), upon grinding, is set to the surface (42) of the fluted-roll blank (41).

16. (New) A method according to claim 11, wherein the grinding device (21), upon grinding of the fluting

heads (15), grinds a part of the two roots (18) that adjoin the heads (15).

17. (New) A method for the manufacture of fluted rolls, in particular for corrugating machines, comprising the following steps:

- providing a fluted-roll blank (41) with a central longitudinal axis (44) and with a longitudinal direction (43) that is parallel thereto and with a surface (42);

- wherein the fluted-roll blank (41) has a swell;

- providing a grinding device (21) for grinding, on the surface (42), flutings (7, 8) that run in the longitudinal direction (43);

- wherein a grinding wheel (27) that is displaceable in the longitudinal direction (43) is used in the grinding device (21);

- wherein the used grinding wheel (27) has two radially projecting annular beads (33, 34) and an annular recess (35) that is disposed there-between and stands back radially; and

- the flutings (7, 8) comprising fluting heads (15) and roots (18) that are parallel to each

other and are regularly and alternately distributed along the circumference of the surface (42); and

- grinding fluting heads (15) on the surface (42) by means of the grinding device (21),

-- the fluting heads (15) having the same cross-sectional curvature in the longitudinal direction (43).

18. (New) A method according to claim 17, wherein the fluted-roll blank (41) has a diameter that varies in the longitudinal direction (43).

19. (New) A method according to claim 17, wherein the annular recess (35) corresponds in cross-sectional shape to the curvature of the fluting heads (15).

20. (New) A method according to claim 17, wherein the grinding wheel (27), upon grinding, is set to the surface (42) of the fluted-roll blank (41).

21. (New) A method according to claim 17, wherein the grinding device (21), upon grinding of the fluting heads (15), grinds a part of the two roots (18) that adjoin the heads (15).